

Work Order ID 139566

Monday, November 30, 2015 11:08:01 AM

139566

Page 1

Item ID: D350-689-021

Accept

N1900040100

Setup Start

NS1

Revision ID:

Item Name: Dual High-Back Seat Installation - Energy Attenuating Seat Compatible

Stop

NS2

Start Date: 11/30/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/10/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: ML5 Date **DEC 02 2015**

Tooling:

Date:

Run Start

NR1

QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D350-689	C								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D350-689-021 CHG006								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

ML5 DEC 22 2015

DAS 28 9-89 DEC 22 2015

DAS 6 27 9-89 DEC 22 2015

DAS 28 9-89 DEC 22 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 139566

Monday, November 30, 2015 11:08:01 AM

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Page 2

Item ID: D350-689-021

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Dual High-Back Seat Installation - Energy Attenuating Seat Compatible

Start Date: 11/30/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/10/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				1			
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-689-021								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
28
9-89
DEC 22 2015MLJ
DEC 22 2015mf
15-12-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : ☐			
Misidentified ☐		Past Due ☐					

Picklist Print

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Page 1

Work Order ID: 139566

139566

Parent Item: D350-689-021

D350-689-021

Parent Item Name: Dual High-Back Seat Installation - Energy Attenuating Seat Compatible

Start Date: 11/30/2015

Required Date: 12/10/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-12-23 new issue DD verified by: LL 08.12.24 IPP
Rev:B chg002 DD 10.02.12 verified by:JLM IPP Rev:C
chg004 DD 11.09.28 verified by:JLM IPP Rev:D 12.01.12
now @ CHG005 (ecn12-501) DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date DAS Issued	Status
D350-689-023		Manufactured	No			110	Each	1.0000	1	1		9-89	
D350-689-023													
Floor Provisions Energy Attenuating Seat Compatible													
	DAS 28 9-89			Location FG027 138381				Loc Qty 1 1					BAS 27 9-89
D350-689-043		Manufactured	No			110	Each	0.0000	1	1		DAS 6 9-89	
D350-689-043													
Dual High Back Seat Assembly-Energy Attenuating Seat Compatible													
D3018-1	DAS 28 9-89	Manufactured	No			110	Each	6.0000	1	1		DAS 6 9-89	BAS 27 9-89
D3018-1													
Seat Cushion													
	DAS 28 9-89			Location Mezz2 132179				Loc Qty 6 6					BAS 27 9-89
D3019-1		Manufactured	No			110	Each	6.0000	1	1			
D3019-1													
Back Cushion													
	DAS 28 9-89			Location Mezz2 132180				Loc Qty 6 6					DAS 6 9-89 BAS 27 9-89

DEC 22 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

REF. ONLY

DAS
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9-89

5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
X						D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X					D350-689-013	FLOOR PROVISIONS KIT
		X				D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH
		1	X			D350-689-023	ENERGY ATTENUATING FLOOR PROVISIONS KIT
1				X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
		1			X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY
1		1				D3018-1	SEAT CUSHION
1		1				D3019-1	BACK CUSHION
	1					D3025-1	BEAM
	1					D3027-1	CLIP
	1					D3027-3	CLIP
	1					D3027-5	CLIP
	4		4			D3027-7	CLIP
				4		D3028-1	STUD
				2		D3029-1	SPRING
				2		D3030-1	LOCK
	1					D3032-1	SPACER
	2					D3033-1	SEAT TRACK
	1					D3234-1	DOUBLER
	2					D3234-5	SPACER
					2	D3808-041	SEAT RAIL ASSEMBLY
					4	D3809-1	SLIDING BLOCK
			1			D3811-041	SEAT TRACK ASSEMBLY
	1		1			D4575-1	BEAM
	1		1			D4575-3	DOUBLER
				1	1	D5162-041	SEAT STRUCTURE ASSEMBLY
			9			MS21042L3	NUT (OR MS21042-3)
	12					MS21059L3	NUTPLATE
	2					MS24693-S273	SCREW
			9			MS24694-S50	SCREW
	6					MS27039-1-10	SCREW
	6					NAS1149D0332J	WASHER (OR AN960JD10L)
			9			NAS1149D0363J	WASHER (OR AN960JD10)

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Revision: C

Date: 14.12.01